

Date:
User:Wednesday, 15/04/2009 3:04:48 PM
Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET
Job Number	: 47233		
Estimate Number	: 13852		
P.O. Number	:	Part Number	: D35704
This Issue	: 15/04/2009 S.O. No. :	Drawing Number	: D3570 REV D PRELIM
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: D PRELIM
Previous Run	: 47219	Material	:
Written By	:	Due Date	: 20/04/2009 Qty: 2 Um: Each
Checked & Approved By	: <u>mf 09-04-15</u>		
Comment	: Est Rev:A New Issue 09.04.14 EC verified by:DD		

Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S125 6061-T6 .125 Sheet



Comment: Qty.: 0.0746 sf(s)/Unit Total : 0.1491 sf(s)
6061-T6 .125 Sheet
Batch: 110062 IB 9-4-16

Grain must be Along 4.63"**

Scrap

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
1-Cut as per Dwg D3570
Dwg Rev: PDE
Prog Rev: Lim

IB 9-4-16

(3)

2-Deburr if necessary IB 9-4-16

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IB 9-4-16

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

09-4-16 (3)

P-10

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

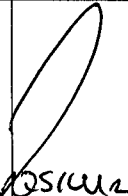

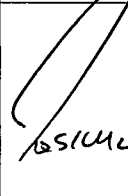
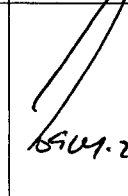
1-Form as per Dwg D3570 Using DT8945

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3570-4 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: FW Date: 09/04/23

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>47233</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09.04.22	4.0	Scrap due to design change. R. C. Prelim design		Scrap: destroy QTY 3 No replace	 09/04/23	SB 09/04/23	 09/04/23	 09/04/22

NOTE: Date & initial all entries

Date: Wednesday, 15/04/2009 3:04:48 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 47233

Part Number: D35704

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Cut excess material per Dwg D3570.

3-Drill as per Dwg D3570 Using Dt8946

6.0

QC5

INSPECT WORK TO CURRENT STEP



**ENGINEERING
APPROVAL**



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock

Location: _____

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 31.04.25

PERFORMATIVE RECALL

DATE: _____ AUTH: _____

DATE: _____ DATE: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

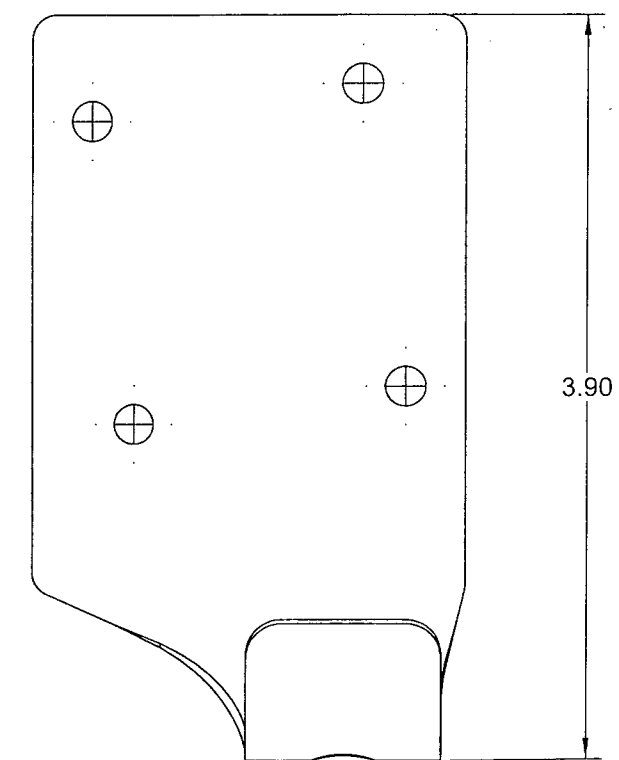
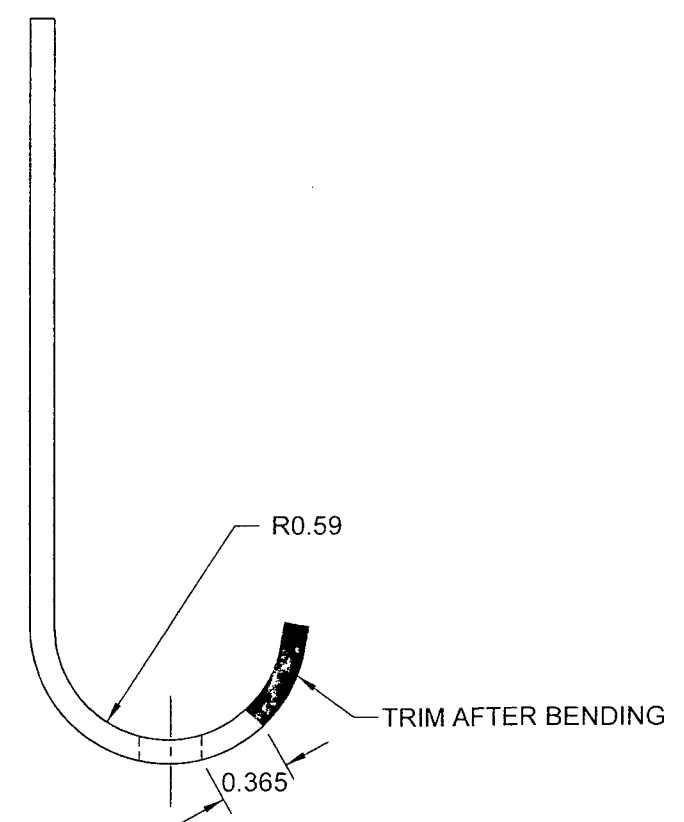
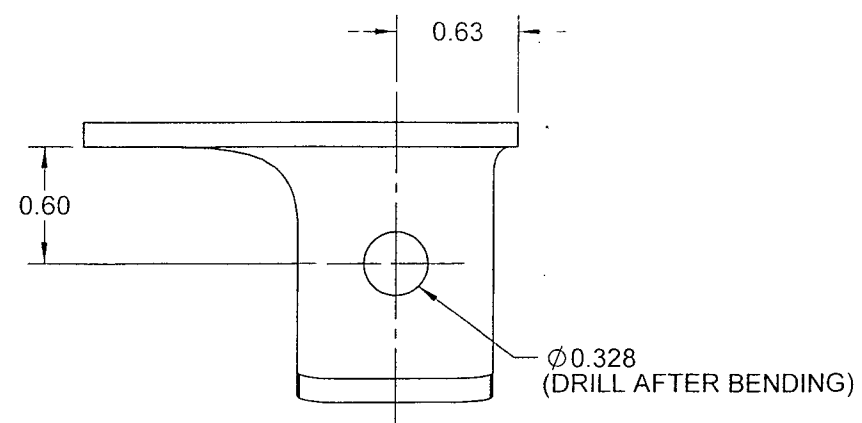
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

7 6 5 4 3 2 1

D
C
B
A

D
C
B
A



PRELIMINARY
ISSUE
AJS 08.04.14

47233

D3570-4 BRACKET
(MAKE FROM D3570-3F)

DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D3570	REV. D
MFG. APPR.			SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	09.04.01	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

8 7 6 5 4 3 2 1